

Work Order ID 66943

Thursday, March 03, 2011 8:45:08 AM



Page 1

Item ID: D3278-2

Accept



Setup Start



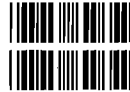
Revision ID:

Stop



Item Name: Support

Start Date: 3/3/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: M Date: 11-03-3 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3278	Rev C

100



SHEAR

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

ml 11/03/16

31 0

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA405 and Dwg D3278-2- Deburr and
Tumble Identify as D3278-2

ml 11/03/18
ml 11.3.21

31

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

ml 11/03/18
ml 11.3.21

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3278-2

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Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 3/3/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		M.A 11/03/22		31	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				31		BR 11-3-22	
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115951 Memo START TIME: 8:10 FINISH TIME: 9:10	0.00 0.00				31		BR 11-3-22	

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Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 3/3/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(31X) m-l 11/03/22

170

Identify as per dwg & Stock Location GA

0.00



Packaging

Memo

0.00

Packaging

SB 11/03/23

(31)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/23 JF

11/03-23
(2)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 8:45:14 AM

Page 1

Work Order ID: 66943

Parent Item: D3278-2

Parent Item Name: Support



Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: ☐A☐04.04.19☐New issue☐KJ/JLM☐
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	53.4303	0.2337	7.38			



6061-T6 Bar 1.00 x 2.00



Location	Loc Qty	Loc Code
MAT	51.972	
112567	0	
114415	3.75	
115045	3.902	
→ 115952	40	
116623	4.32	
MAT03	1.4583	
112567	1.4583	

7.38 *and 11/03/16*

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66943
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.099	—		Vern ML-7	
0.359	+/-0.005	.359	—		"	
0.609	+/-0.010	.613	—		"	
0.250	+/-0.010	.250	—		"	
1.480	+/-0.005	1.480	—		"	
R0.125	+/-0.010	R.125	—		Rad-gage	
0.119	+0.005/-0.004	.121	—		Vern ML-7	
2.439	+/-0.010	2.440	—		"	
1.980	+/-0.010	1.980	—		"	
R0.13	+/-0.030	R.130	—		Rad-gage	
Ø0.257	+0.005/-0.000	Ø.258	—		Vern ML-7	
R0.375	+/-0.010	R.375	—		Rad-gage	
0.875	+/-0.010	.875	—		Vern ML-7	
0.500	+/-0.010	.500	—		"	
R0.400	+/-0.010	R.400	—		Rad-gage	
R1.00	+/-0.030	R1.00	—		"	
1.720	+/-0.010	1.718	—		Vern ML-7	
R0.125	+/-0.010	R.125	—		Rad-gage	
0.125	+/-0.010	.125	—		Vern ML-7	

Measured by:	SMF	Audited by:	B.A	Prototype Approval:	N/A
Date:	11/03/18	Date:	11/03/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	AF

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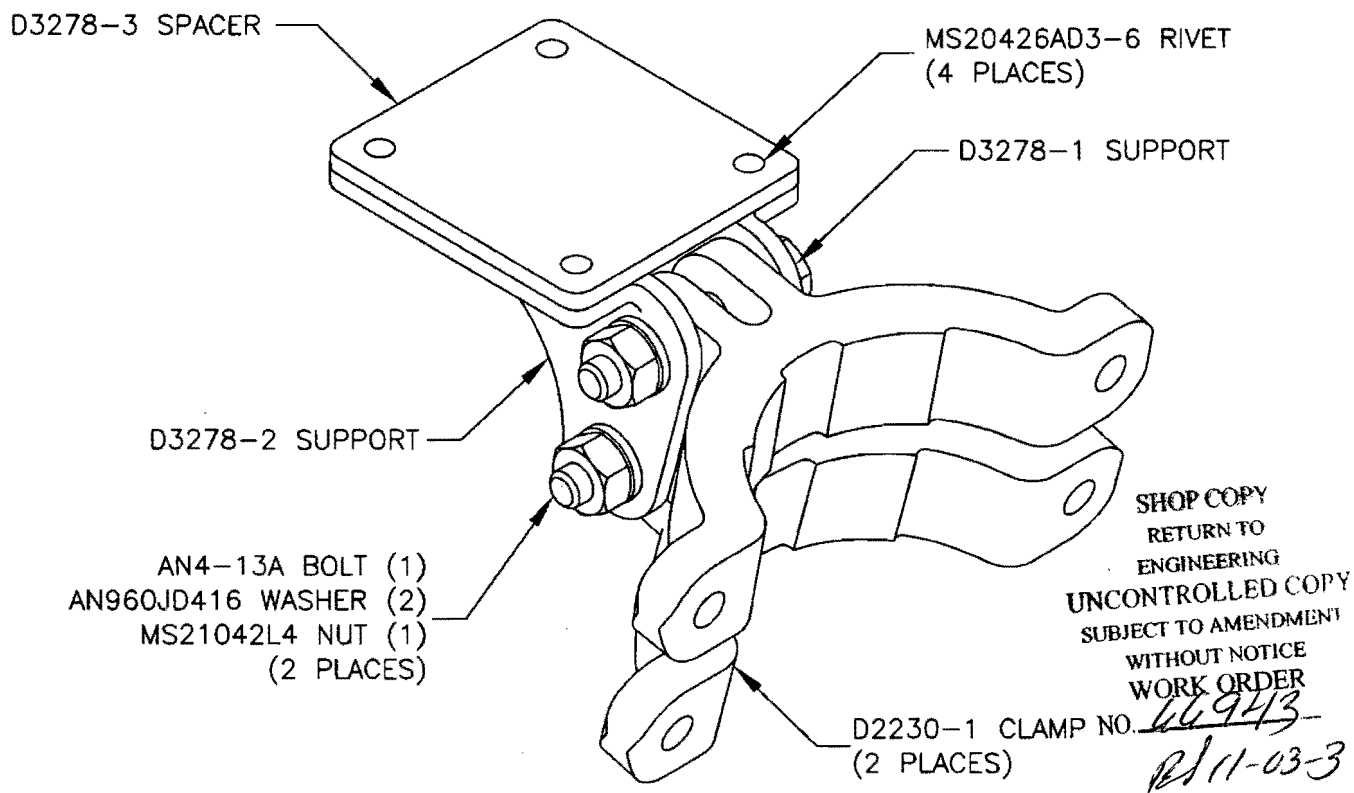
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-18

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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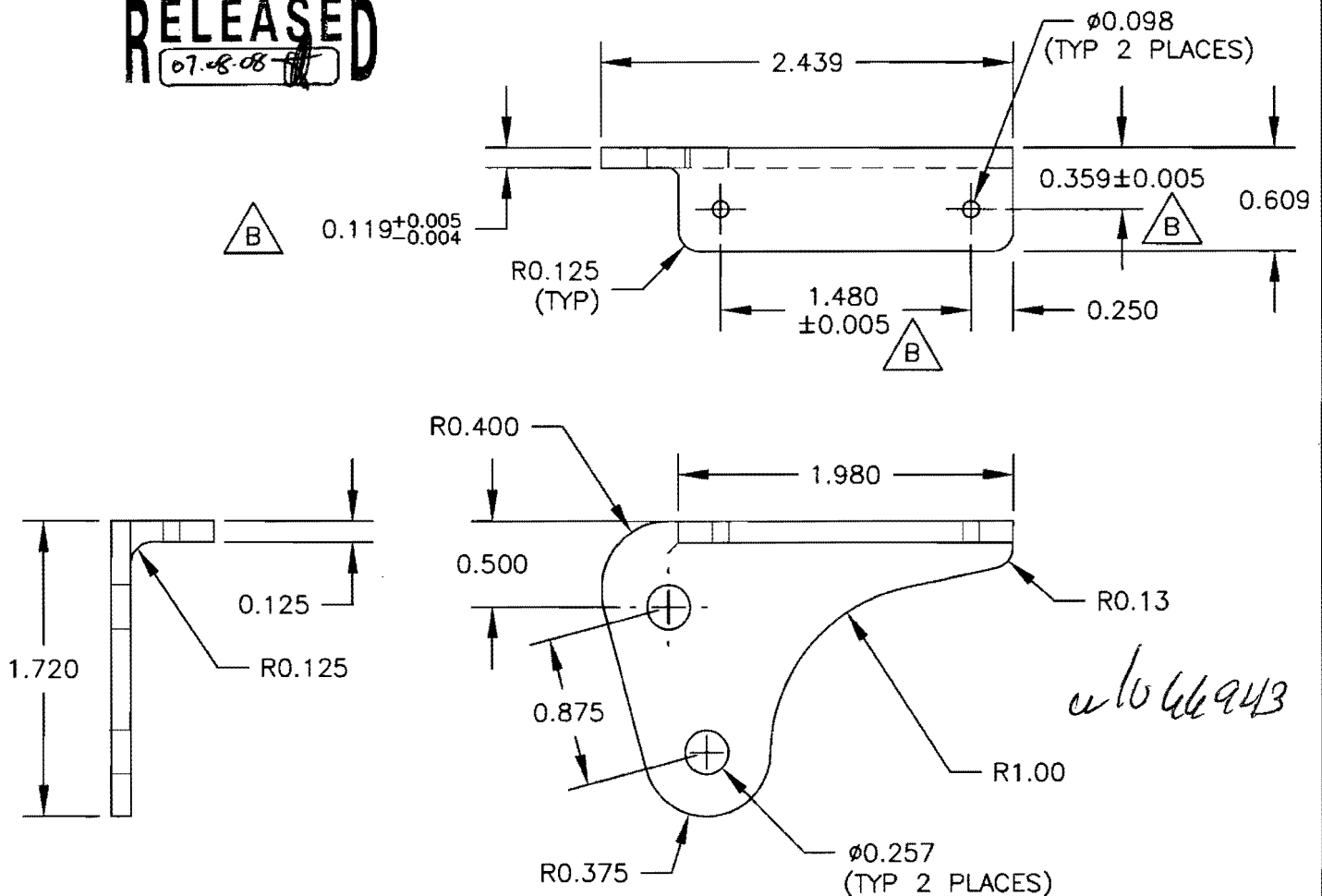
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DESIGN <i>921</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRF"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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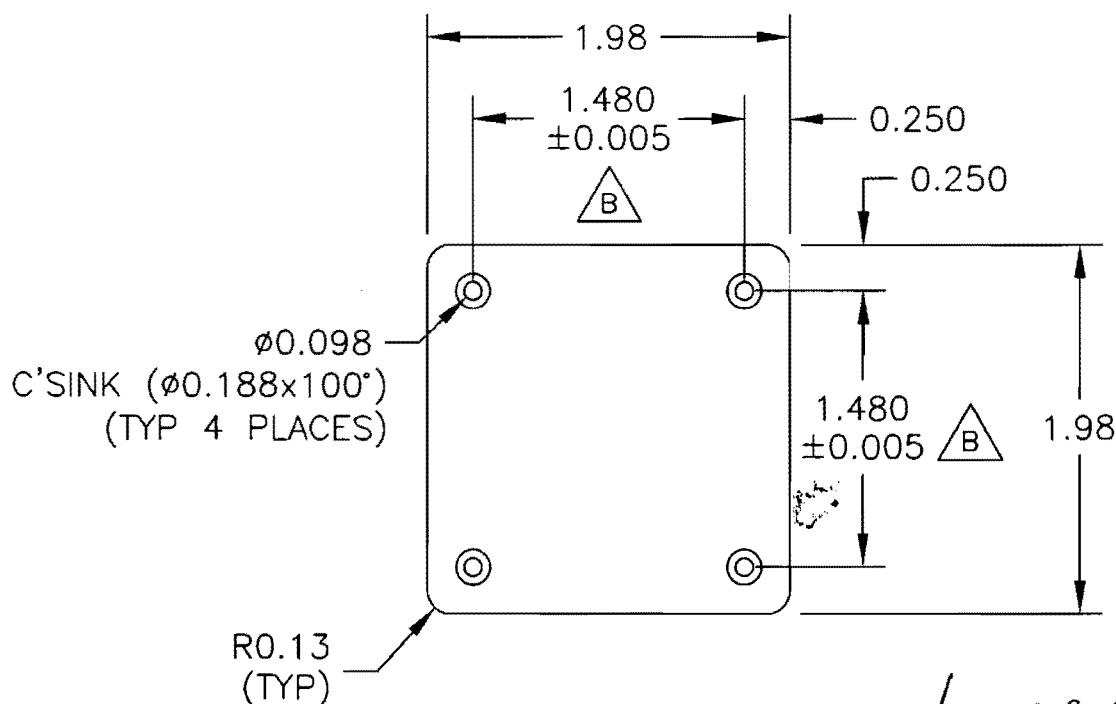
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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